

Work Order ID 56096

February 10, 2010 12:15:33 PM



Page 1

Item ID: D3462-1

Accept



Setup Start



Revision ID:

Stop



Item Name: BRACKET ASSEMBLY

Start Date: 2/10/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: *10-2-10* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3462

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3462 ☒ Dwg Rev: *C* ☐ Prog Rev: *C* ☐ 2-
Deburr if necessary

IB 10-2-12

(8)

304 125

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 10-2-12

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ 8/10/2/10

(+8)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130 | Small Fab | 0.00 | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | Deburr if necessary. | | | | | | | | |
| | | <i>u/w S</i> | | | | | | | |
| 140 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 150 | Identify as per dwg & Stock Location: <i>Carl</i> | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

10-2-11 *TSF*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 56096

February 10, 2010 12:15:33 PM



Page 3

Item ID: D3462-1

Accept



Setup Start



Revision ID:

Stop



Item Name: BRACKET ASSEMBLY

Start Date: 2/10/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/18
MF
10-2-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

February 10, 2010 12:15:36 PM

Page 1

Work Order ID: 56096



Parent Item: D3462-1



Parent Item Name: BRACKET ASSEMBLY

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP REV. A 05.11.18 NEW ISSUE EC
IPP Rev:B Now on Waterjet 06-06-16 JLM
esr rev B 08.07.15 ecn 1049 EC verified by: DD

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Remaining | Qty | Date | Status |
|--------------------|-------------|-----------|-----|---------|------|-------|---------|---------|-----------|-----|------|--------|
| M304S11GA | | Purchased | No | | | 100 | sf | 81.7878 | 0.6000 | 18 | | |



304/316 0.125 Sheet



HB 10-2-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

112663

81.7878

81.7878

112663

8

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

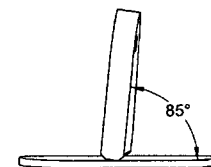
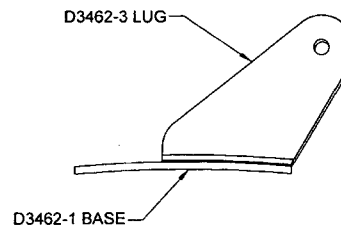
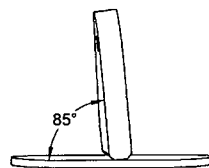
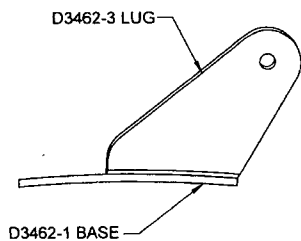
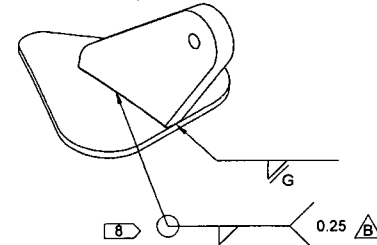
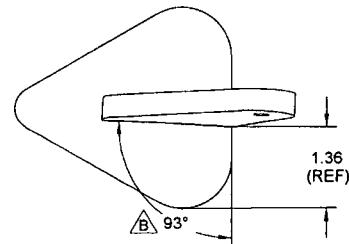
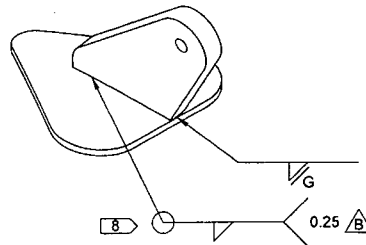
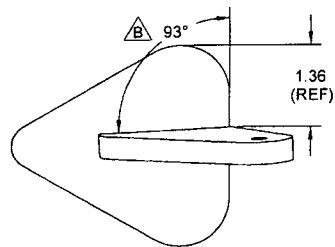
Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 36096

10-2-10

| QTY -041 | QTY -042 | P/N | DESCRIPTION |
|-------------|-------------|-----------|------------------|
| X | | D3462-041 | BRACKET ASSEMBLY |
| | X | D3462-042 | BRACKET ASSEMBLY |
| 1 | 1 | D3462-1 | BASE |
| 1 | 1 | D3462-3 | LUG |

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

| | | | |
|------------|--|----|----------|
| C | SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY | DC | 07.10.24 |
| B | REVISE DIMENSIONS | RF | 05.12.05 |
| A | NEW ISSUE | RF | 05.09.20 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 07.10.24 | | |

| | |
|---|--------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D3462 | REV. C |
| TITLE BRACKET ASSEMBLY | SHEET 1 OF 2 |
| SCALE 1:2 | |
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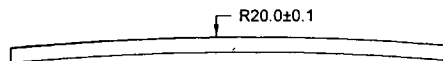
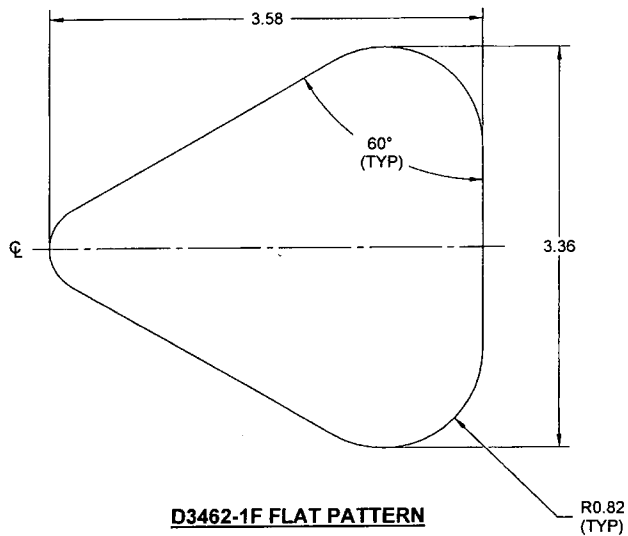
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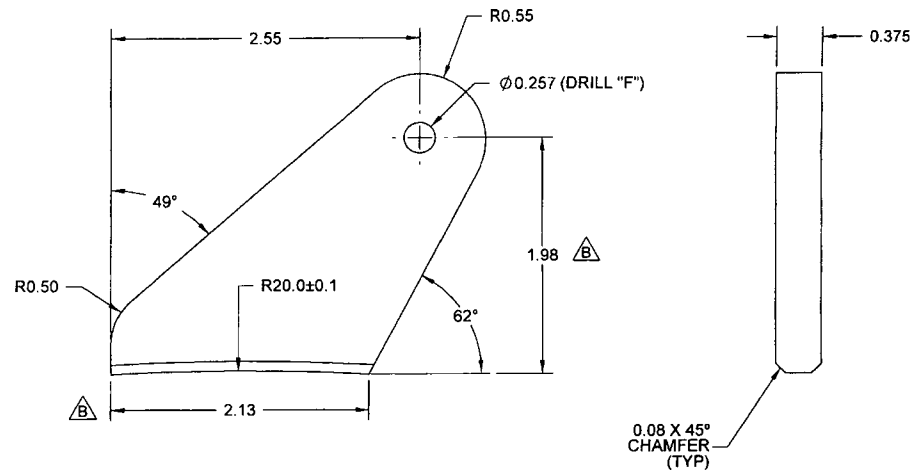
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



- NOTES:**
- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED), 2B FINISH
(REF. DART SPEC. M304S11GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.28 lbs



- NOTES:**
- 1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

w/o 56096

RELEASED
8/10/11

| | | | |
|------------|--------------------|---|--------------|
| DESIGN | 7F | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | <i>[Signature]</i> | DRAWING NO. | REV. C |
| CHECKED | <i>[Signature]</i> | D3462 | SHEET 2 OF 2 |
| MFG. APPR. | <i>[Signature]</i> | TITLE | SCALE |
| APPROVED | <i>[Signature]</i> | BRACKET ASSEMBLY | 1:1 |
| DE APPR. | <i>[Signature]</i> | COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |
| DATE | 07.10.24 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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